

Work Order ID 105599

Thursday, August 08, 2013 1:22:22 PM

105599

Page 1

Item ID: D3492-055

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plug Assembly

Start Date: 8/8/2013 Start Qty: 12.00 ***12***

Required Date: 8/15/2013 Req'd Qty: 12.00 ***12***

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *MLJ* Date: *13-08-08*

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3492

6 PE1 13-08-08

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FB204 & Dwg D3492Dwg Rev: _____ Folio
Rev: *PE1*

*DAS
44
9-08*

13/08/08

12

Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

*DAS
44
9-08*

13/08/08

12

Ø

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/

13-8-8

12

Ø

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QC:

Date:

SPC (Y/N):

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Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Debur

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

WAS

12 11/13-8-9

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Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

0.00

Powder Coating

(Flat End Only)START TIME:

OVEN

TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

0.00

Packaging

12x 1/2" M-F 13/08/09

12x 1/2" M 13/08/09

12x 1/2" M 13/08/09

W126125

7:15
320 36- 7:45

172-001

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Accept

N9000040100

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Stop ***NS2***

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12

Required Date: 8/15/2013 Req'd Qty: 12.00

12

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

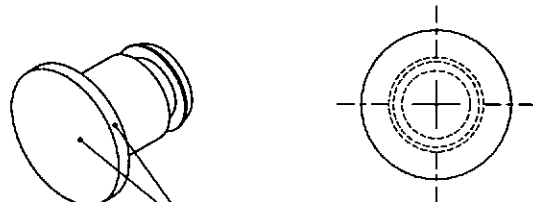
0.00

Quality Control

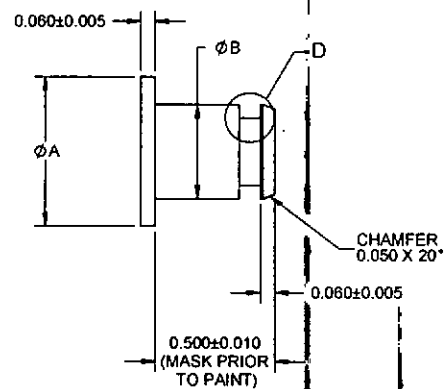
MLJ 13-08-13

MLJ 13-08-09

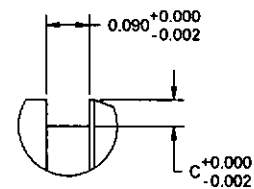
8 7 6 5 4 3 2 1



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875



PRELIMINARY
(13.08.08) AP

NOTES:

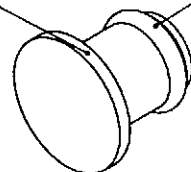
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

PE1

PE1

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

PE1	ADD -055PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	NTS
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12/1/77